

MUST SHIP FRIDAY OCT 30

Work Order ID 53262

October 29, 2009 11:05:34 AM

Page 1

Item ID: D3709-3

Accept

Setup Start

Revision ID: A

Stop

Item Name: Angle

Start Date: 10/29/09 Start Qty: 1.00

Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3709	Rev A
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0.00

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3709 Dwg Rev: A ☐ Prog Rev: A

☐

****grain direction on a 45 degree **** ☐ 2- Deburr if necessary

109-10-29

3

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

109-10-29

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

27 8-2/10/09

3

6

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Page 2

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Required Date: 10/30/09 Req'd Qty: 1.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
	Memo	0.00							
	Form as per dwg D3709								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
	Hand Finishing								

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			MO 09/10/30				X1		
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
			9/10/30				RD SP		
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
			09/11/02						
			mf						
			69-10-30						

Picklist Print

Page 1

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Work Order ID: 53262



Parent Item: D3709-3RevA



Parent Item Name: Angle

Start Date: 10/29/09

Required Date: 10/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	227.7841	0.2800			
6061-T6 .063 Sheet												

13 9-10-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

227.7841211

110551

33.2841211

112939

194.5

112939

w/o 53262

D3709-3 ANGLE

D3709-1 ANGLE

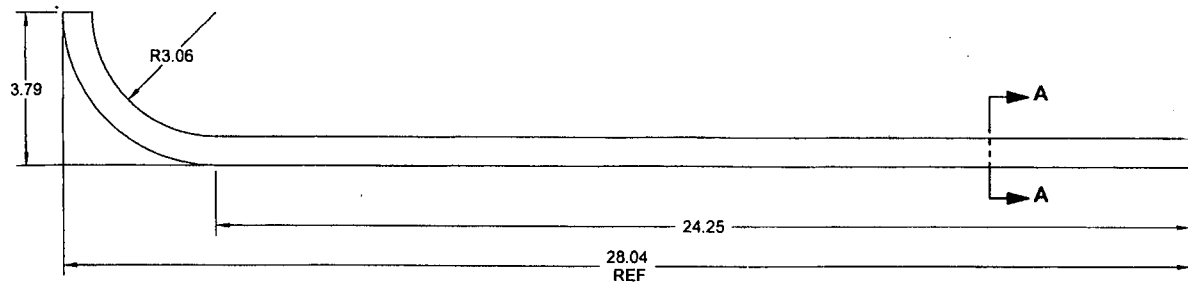
RELEASED
2/16/97

NOTES:

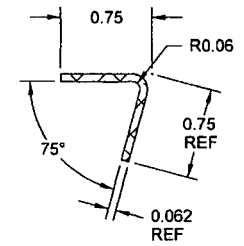
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

A	NEW ISSUE		DESCRIPTION	MB	08.05.02
REV.				BY	DATE
DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN					
CHECKED					
MFG. APPR.				DRAWING NO.	REV. A
APPROVED				D3709	SHEET 1 OF 3
				TITLE	SCALE
DE APPR.				ANGLE	NTS
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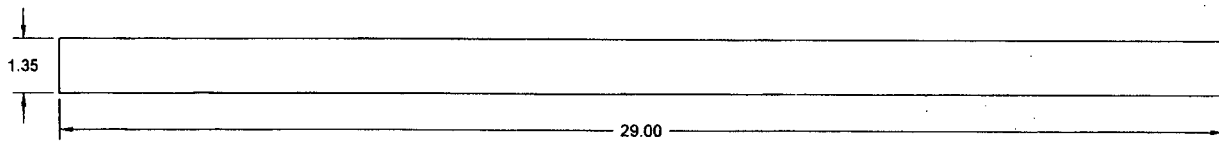
W/O 53262



D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X

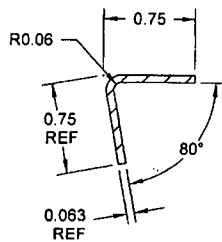


D3709-1F ANGLE FLAT PATTERN

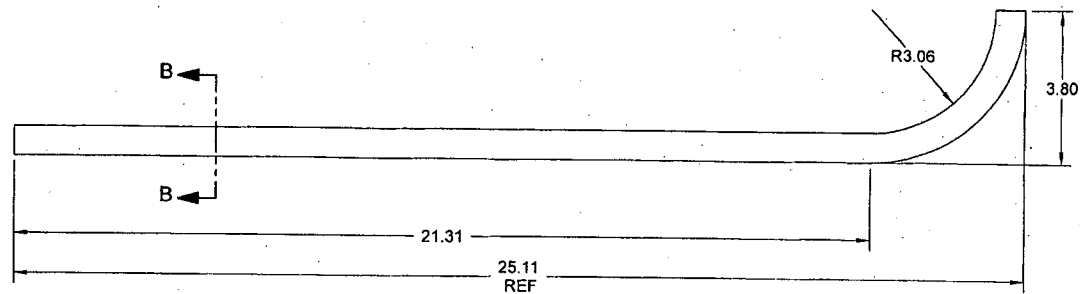
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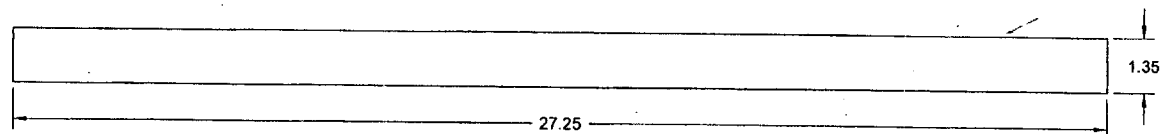


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

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08/04/08

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